

Work Order ID 89586

Monday, August 27, 2012 7:50:50 AM

89586

Page 1

Item ID: D2873-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly

Start Date: 8/27/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 8/31/2012 Req'd Qty: 20.00 ***20*** Customer:

Reference: *12-08-27*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID - Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|------------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | |
| D2873 | Rev A | | | | | | | |

100 BAND SAW 0.00
100
 Bandsaw Memo 0.00 *PO 12/08/27* 20 Ø
 Jeaspa Bandsaw Cut blanks: 1.000" x 0.375" x 2.700" long

110 HAAS CNC VERTICAL MACHINING #1 0.00
110
 HAAS 1 Memo 0.00 *PO 12/08/27* 20 Ø
 HAAS CNC vertical machine #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-5
 Dwg Rev A F1819 Folio Rev AA

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120
 QC Memo 0.00 *PO 12/08/27* 20 Ø
 Quality Control

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Item ID: D2873-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nut Plate Assembly

Start Date: 8/27/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 8/31/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12-08-28

130

QC

Memo

0.00

(20)

Quality Control

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

1-Deburr 2- C'sink as per Dwg D2873

20x

JP 12/08/28

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS 16 2-23 17/08/28

60x20

Page 3

1-Assemble as per Dwg D2873 2-Identify as D2873-045

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Item ID: D2873-045

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Nut Plate Assembly

Start Date: 8/27/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 8/31/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

Quality Control

0.00

200

Identify as per dwg & Stock Location: L-tube

0.00

200

Packaging

Memo

Packaging

0.00

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

Quality Control

0.00

DAS
16
2-29

12/08/29

20X

20

12-08-29

MLJ 12/08/30

MF
12-08-30

Picklist Print

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Page 1

Work Order ID: 89586

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly

Start Date: 8/27/2012

Required Date: 8/31/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.375X01.000 6061T6 BAR .375 x 1.00 | | Purchased | No | | | 180 | f | 24.3760 | 0.225 | 4.7368421 | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT001 | 2.292 | |
| 118641 | 2.292 | |
| MAT002 | 22.084 | |
| 120603 | 0.76 | |
| 120866 | 0.76 | |
| 121192 | 0.046 | |
| → 121836 | 20.518 | |

P0 +2/08/26
12/08/27

MS20426AD4-6
Rivet

Purchased No

180 Each 1,256.8870

4 80

EP 12/08/29

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST317 | 1255 | |
| 110139 | 187 | |
| 118510 | 13 | |
| 119436 | 85 | |
| 121708 | 970 | |
| ST334 | 1.887 | |
| 122814 | 1.887 | |

80

MS21075L5
Nut Plate

Purchased No

100 Each 206.0000

2 40

EP 12/08/29

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST321 | 206 | |
| 121827 | 206 | |

40

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 89506 |
| Description: Radius Block | | Part Number: | D2873-5 |
| Inspection Dwg: D2873 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------------|------------------|--------|--------|----------------------|----------|
| 2.50 | +/-0.030 | 2.499 | ✓ | | VERN | P40-01 |
| 1.000 | +/-0.010 | 1.000 | ✓ | | " | " |
| 0.750 | +/-0.010 | 0.747 | ✓ | | " | " |
| 0.250 | +/-0.010 | 0.247 | ✓ | | " | " |
| 1.000 | +/-0.010 | 1.000 | ✓ | | " | " |
| 2.000 | +/-0.010 | 2.000 | ✓ | | " | " |
| Ø0.128 | +0.005/-0.001 | 0.129 | ✓ | | " | " |
| 0.359 | +/-0.010 | 0.359 | ✓ | | " | " |
| Ø0.316 | +0.006/-0.001 | 0.317 | ✓ | | " | " |
| 1.000 | +/-0.010 | 1.004 | ✓ | | " | " |
| 0.250 | +/-0.010 | 0.248 | ✓ | | " | " |
| 0.061 | +/-0.010 | 0.061 | ✓ | | " | " |
| Ø0.230 x 0.125 | +0.005/-0.001 x 0.010 | 0.230 x 0.123 | ✓ | | " | " |
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|------------------------|-----------------------|----------------------------|-----|
| Measured by: Pp | Audited by: SL | Prototype Approval: | N/A |
| Date: 12/08/27 | Date: 12-08-28 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 06.08.30 | New Issue P/O D2873-045 | KJ/JLM | |

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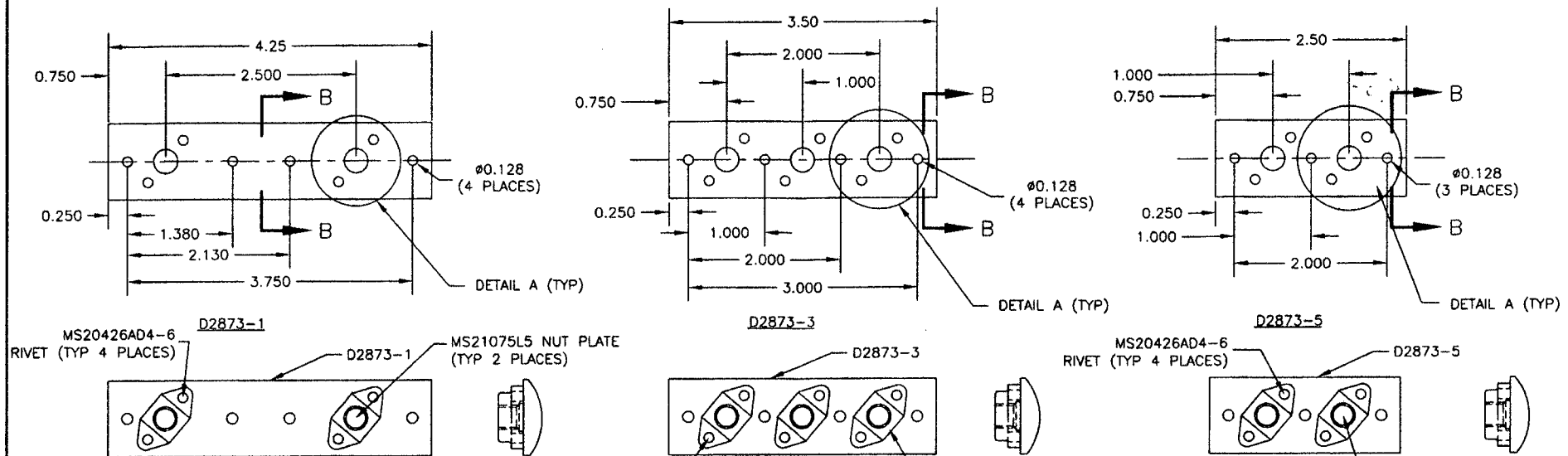
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D2873-1/-3/-5 RADIUS BLOCK

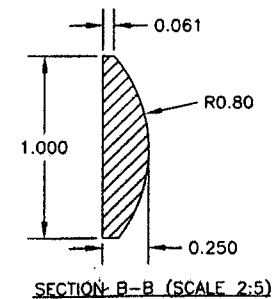
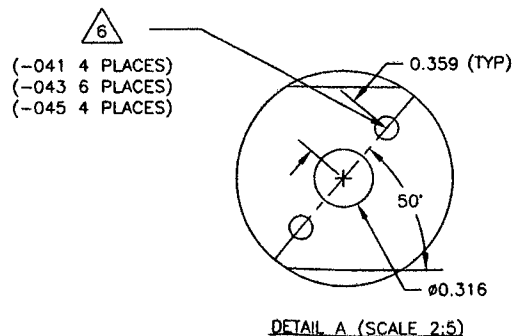
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100"

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

| -041 | -043 | -045 | PART NUMBER | DESCRIPTION |
|------|------|------|--------------|--------------------|
| X | | | D2873-041 | NUT PLATE ASSEMBLY |
| | X | | D2873-043 | NUT PLATE ASSEMBLY |
| | | X | D2873-045 | NUT PLATE ASSEMBLY |
| 1 | | | D2873-1 | RADIUS BLOCK |
| | 1 | | D2873-3 | RADIUS BLOCK |
| | | 1 | D2873-5 | RADIUS BLOCK |
| 4 | 6 | 4 | MS20426AD4-6 | RIVET |
| 2 | 3 | 2 | MS21075L5 | NUT PLATE |



RELEASED
05-07-26

| | | |
|---------------|--------------------|--|
| A | 05.07.26 | NEW ISSUE |
| DESIGN PH | DRAWN BY PH | DART DART AEROSPACE LTD MISSISSAUGA, ONTARIO, CANADA |
| CHECKED DS | APPROVED DS | DRAWING NO. D2873 |
| DATE 05.07.26 | TITLE RADIUS BLOCK | REV. A SHEET 1 OF 1 SCALE 4:5 |

